

Ship May 2

Work Order ID 67884



Monday, April 04, 2011 9:22:44 AM

Item ID: D4030-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Long Basket Assembly (350)

Start Date: 4/4/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 4/11/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 67884

Monday, April 04, 2011 9:22:44 AM



Page 2

Item ID: D4030-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Long Basket Assembly (350)

Start Date: 4/4/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 4/11/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

PPG 7883

0.00

Packaging

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

Monday, April 04, 2011 9:22:50 AM

Page 1

Work Order ID: 67884

Parent Item: D4030-041

Parent Item Name: Long Basket Assembly (350)



Start Date: 4/4/2011

Required Date: 4/11/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A new issue DD 10.03.23 verified by:EC IPP Rev:B as
per dwg revB DD 10.04.20 verified by:EC IPP Rev:C as per dwg
revC DD 10.08.18 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2530 Handle Weldment		Manufactured	No			100	Each	13.0000	1	1			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST506		13							
				66171		5							
				66563		8							
D2535 Spring		Manufactured	No			100	Each	65.0000	2	2			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST504		65							
				64280		11							
				66764		54							
D2537 Bushing		Manufactured	No			100	Each	58.0000	2	2			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST504		58							
				65077		16							
				66972		42							
D3913-041 Long Basket Base Assembly, 350		Manufactured	No			100	Each	0.0000	1	1			

BG 7886 (12)

EP 11/05/02

W/O:		WORK ORDER CHANGES					
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Monday, April 04, 2011 9:22:50 AM

Work Order ID: 67884



Parent Item: D4030-041



Parent Item Name: Long Basket Assembly (350)

Start Date: 4/4/2011

Required Date: 4/11/2011

Start Qty: 1.00

Required Qty: 1.00

D3914-041 Manufactured No



Long Basket Lid Assembly (350)

D3917-3 Manufactured No



Washer

100 Each 0.0000

B67886 (N)

1



11/05/02

100 Each 20.0000

6



B67780 11/4/298

Location

Loc Qty

Loc Code

ST092

20

66903

20

D3953-3 Manufactured No



Gas Spring Stud, Lid

D3953-7 Manufactured No



Spring Spacer

100 Each 0.0000

2



B68230

100 Each 7.0000

2



B68464

Location

Loc Qty

Loc Code

ST096

7

65053

4

65621

3

D3953-9 Manufactured No



Gas Spring Washer

100 Each 16.0000

2



B68231 11/4/298

Location

Loc Qty

Loc Code

ST089

16

66162

16

W/O:		WORK ORDER CHANGES					
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Monday, April 04, 2011 9:22:50 AM

Page 3

Work Order ID: 67884

Parent Item: D4030-041



Parent Item Name: Long Basket Assembly (350)

Start Date: 4/4/2011

Required Date: 4/11/2011

Start Qty: 1.00



Required Qty: 1.00

D3953-17 Manufactured No 100 Each 8.0000 2 2
  *B67968 SP*

Gas Spring Spacer

Location Loc Qty Loc Code



ST096 8
 65138 8

D3953-19 Manufactured No 100 Each 9.0000 1 1
  *SP*

Gas Spring Bracket

Location Loc Qty Loc Code



ST096 9
 59213 1
 64810 8

D3953-21 Manufactured No 100 Each 8.0000 1 1
  *SP*

Gas Spring Bracket

Location Loc Qty Loc Code



ST096 8
 66110 8

D3969-3 Manufactured No 100 Each 4.0000 1 1
  *B68653 SP*

Spring (Basket Lid)

Location Loc Qty Loc Code

ST272 4
 64285 4

AN3-14A Purchased No 100 Each 23.0000 4 4
  *M175138 11/4/29 SP*

Bolt

Location Loc Qty Loc Code

ST351 23
 116978 23

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Shop Packet Print

Page 3

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

Monday, April 04, 2011 9:22:51 AM

Page 4

Work Order ID: 67884

Parent Item: D4030-041


Parent Item Name: Long Basket Assembly (350)

Start Date: 4/4/2011

Required Date: 4/11/2011


Start Qty: 1.00

Required Qty: 1.00

AN3-16A Purchased No 100 Each 69.0000 2

 Bolt


Location Loc Qty Loc Code

ST352 69
 114752 19
 116419 50

AN5-17A Purchased No 100 Each 74.0000 4

 Bolt


Location Loc Qty Loc Code

ST339 74
 116590 74

AN4-12 Purchased No 100 Each 42.0000 3

 Bolt


Location Loc Qty Loc Code

ST357 42
 116786 42

AN310-4 Purchased No 100 Each 30.0000 3

 NUT

Location Loc Qty Loc Code

ST324 30
 116786 30

AN310C4 Purchased No 100 Each 34.0000 2

 Nut

Location Loc Qty Loc Code

ST324 34
 116741 34

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Shop Packet Print

Page 4

W/O:		WORK ORDER CHANGES					
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Monday, April 04, 2011 9:22:51 AM

Page 5

Work Order ID: 67884

Parent Item: D4030-041

Parent Item Name: Long Basket Assembly (350)

Start Date: 4/4/2011

Required Date: 4/11/2011

Start Qty: 1.00

Required Qty: 1.00

MS21042L3

Purchased

No

100

Each

2,099.000

6

6



Nut

Location

Loc Qty

Loc Code

ST300

2099

116391

499

116540

800

116549

800

MS21042L5

Purchased

No

100

Each

861.0000

4

4



Nut

Location

Loc Qty

Loc Code

ST300

861

115594

101

116105

500

116548

260

MS24665-151

Purchased

No

100

Each

517.0000

3

3



Cotter Pin

Location

Loc Qty

Loc Code

ST309

517

17566

517

MS24665-300

Purchased

No

100

Each

98.0000

2

2



Cotter Pin

Location

Loc Qty

Loc Code

ST309

98

116823

98

NAS1149F0432P

Purchased

No

100

Each

0.0000

6

6



Washer

11/17/291 11/14/2981

Monday, April 04, 2011 9:22:52 AM

Shop Packet Print

Page 5

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Monday, April 04, 2011 9:22:52 AM

Page 6

Work Order ID: 67884

Parent Item: D4030-041

Parent Item Name: Long Basket Assembly (350)

Start Date: 4/4/2011

Required Date: 4/11/2011

Start Qty: 1.00

Required Qty: 1.00

NAS1149F0563P Purchased

No

100

Each

89.0000

4



Washer

Location

Loc Qty

Loc Code

ST275

89

114576

89

NAS1149F0332P Purchased

No

100

Each

22.0000

8



WASHER

Location

Loc Qty

Loc Code

ST275

22

18057

22

NAS1149C0432R Purchased

No

100

Each

1,614.000

2



Washer

Location

Loc Qty

Loc Code

ST297

1614

116900

1614

Monday, April 04, 2011 9:22:52 AM

Shop Packet Print

Page 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

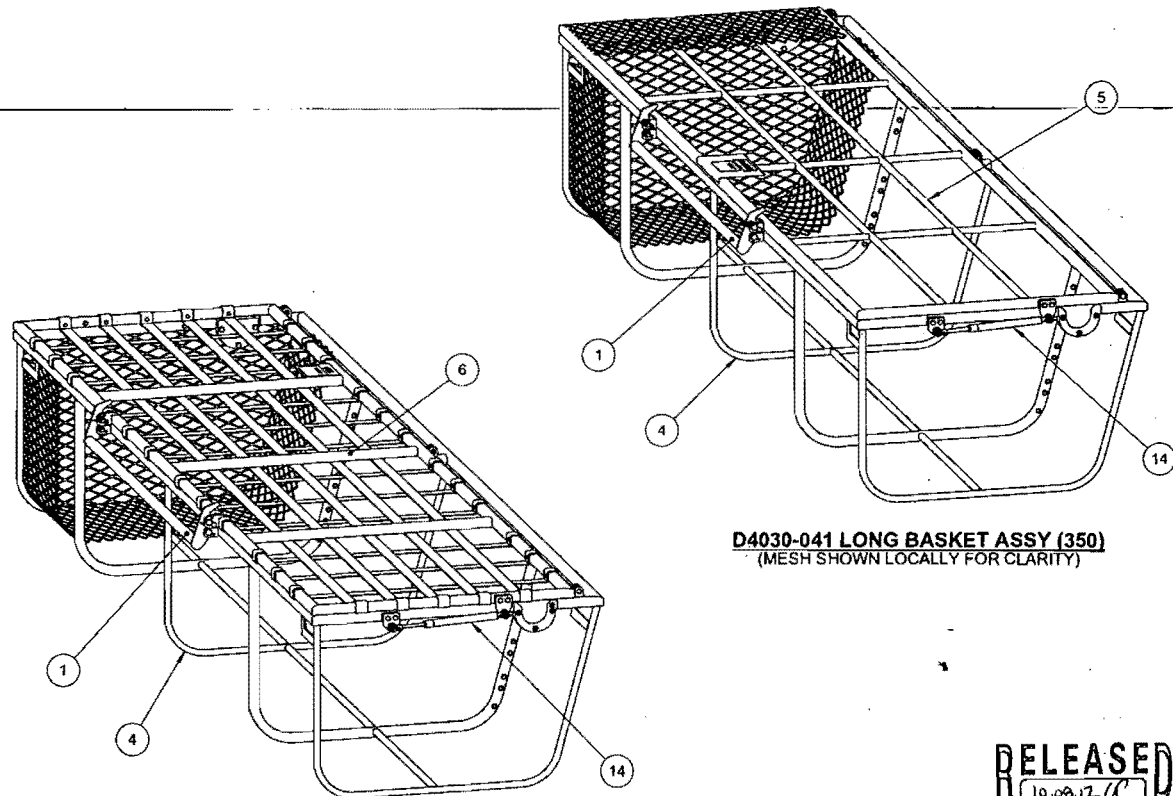
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
	X		D4030-041	LONG BASKET ASSY (350)
		X	D4030-043	LONG BASKET ASSY, LIGHT LID (350)
1	1	1	D2530	HANDLE WELDMENT
2	2	2	D2535	SPRING
3	2	2	D2537	BUSHING
4	1	1	D3913-041	LONG BASKET BASE ASSY (350)
5	1		D3914-041	LONG BASKET, LID ASSY (350)
6		1	D3915-041	LIGHT LID ASSY-LONG BASKET
7	6	6	D3917-3	WASHER
8	2	2	D3953-3	GAS SPRING STUD, LID
9	2	2	D3953-7	GAS SPRING SPACER
10	2	2	D3953-9	GAS SPRING WASHER
11	2	2	D3953-17	GAS SPRING SPACER
12	1	1	D3953-19	GAS SPRING BRACKET
13	1	1	D3953-21	GAS SPRING BRACKET
14	1	1	D3969-3	SPRING
15	4	4	AN3-14A	BOLT
16	2		AN3-16A	BOLT
17		2	AN3-20A	BOLT
18	3	3	AN4-12	BOLT (DRILLED)
19	4	2	AN5-17A	BOLT
20		2	AN5-21A	BOLT
21	3	3	AN310-4	NUT, CASTELLATED
22	2	2	AN310C4	NUT, CASTELLATED
23	6	6	MS21042L3	NUT
24	4	4	MS21042L5	NUT
25	3	3	MS24665-151	COTTER PIN
26	2	2	MS24665-300	COTTER PIN
27	6	6	NAS1149F0432P	WASHER
28	4	4	NAS1149F0563P	WASHER
30	8	8	NAS1149F0332P	WASHER
31	2	2	NAS1149C0432R	WASHER



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 67884
RS11-044

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: -041: 72 lbs APPROX
-043: 57 lbs APPROX

RELEASED
10.08.12
ECN 10-596

C	QTY FOR ITEMS #30 & #31 UNDER -043 WERE MISSING (B8-1); QTY FOR ITEM #3 WAS 4 (D6-1), ONLY 2 ARE REQUIRED. AFFECTS SECTION C-C (D3-3).	MB	10.07.23
B	AN5-21A BOLT WAS AN5-19A: BOM & (D3-3)	JPH	10.04.06
A	NEW ISSUE	JPH	10.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	AS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JP		
CHECKED	JP	DRAWING NO.	REV. C
MFG. APPR.	JP	D4030	SHEET 1 OF 3
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	LONG BASKET ASSY (350)	NTS
DATE	10.07.23	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

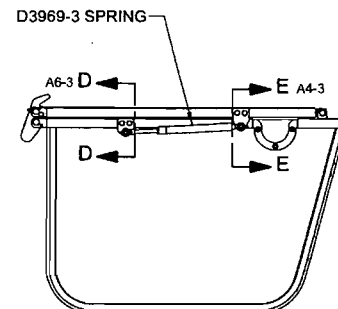
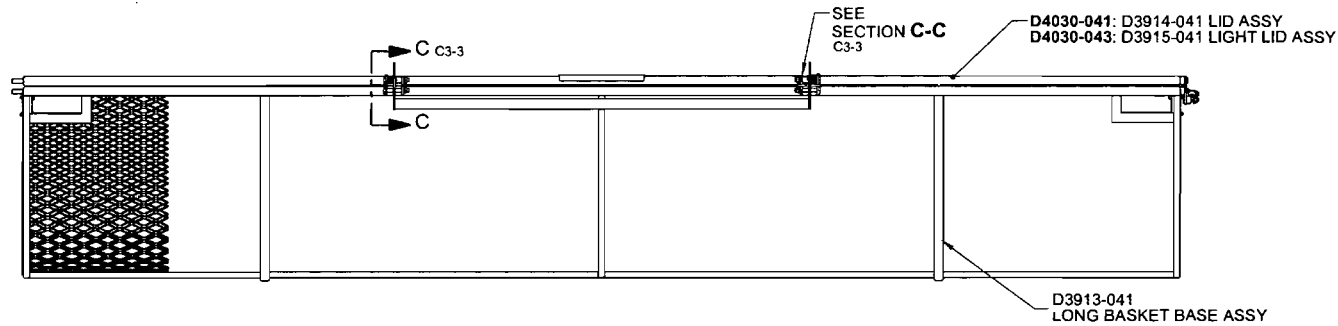
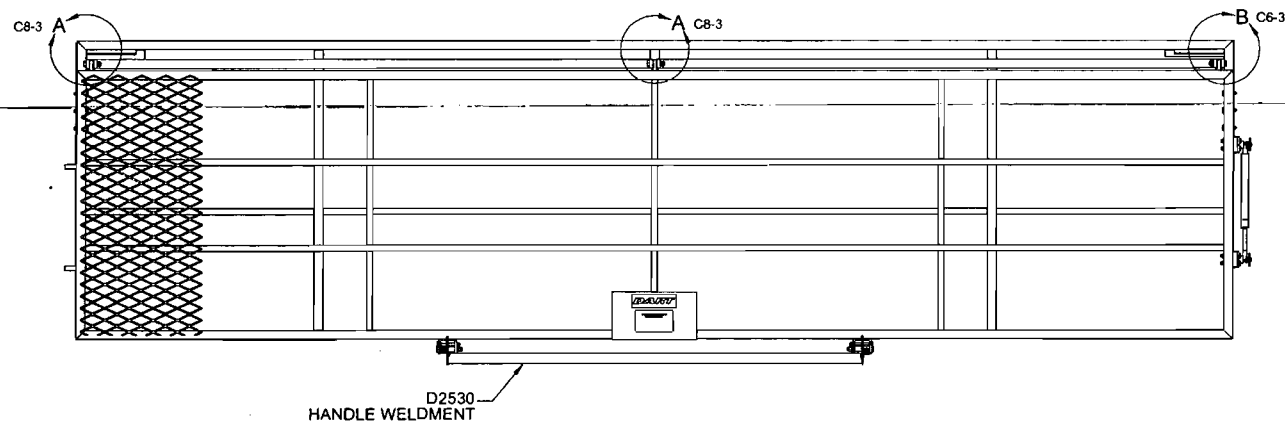
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



D4030-041 LONG BASKET ASSY (350) (SHOWN)
(MESH SHOWN LOCALLY OR REMOVED FOR CLARITY)

D4030-043 SHORT BASKET ASSY, LIGHT LID (350)
(MESH SHOWN LOCALLY FOR CLARITY)

RELEASED
10.08.12

w/0 67884

DESIGN	AS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.	SE	D4030	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET ASSY (350) _ _ NTS.	
DATE	10.07.23	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1

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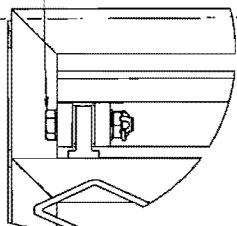
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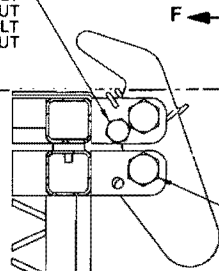
NOTE: Date & initial all entries

AN4-12 BOLT
D3917-3 WASHER, 2X
NAS1149F0432P WASHER, 2X
AN310-4 NUT, CASTELLATED
MS24665-151 COTTER PIN



DETAIL A D8-2
D5-2

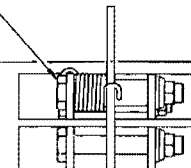
D4030-041: AN3-16A BOLT
MS21042L3 NUT
D4030-043: AN3-20A BOLT
MS21042L3 NUT



SECTION C-C B4-2
B6-2

D4030-041: AN5-17A BOLT
D2537 BUSHING
D2535 SPRING
NAS1149F0563P WASHER
MS21042L5 NUT

D4030-043: AN5-21A BOLT
D2537 BUSHING
D2535 SPRING
NAS1149F0563P WASHER
MS21042L5 NUT



D2530
HANDLE WELDMENT
REF

VIEW F-F C3-3

D3953-17 GAS SPRING SPACER
D3953-21 GAS SPRING BRACKET
AN3-14A BOLT
NAS1149F0332P WASHER, 2X
MS21042L3 NUT
2 PL

D3953-3 GAS SPRING STUD, LID
D3953-7 GAS SPRING SPACER
D3953-9 GAS SPRING SPACER
NAS1149C0432R WASHER
AN310C4 NUT, CASTELLATED
MS24665-300 COTTER PIN

D3969-3 SPRING
REF

SECTION D-D B2-2

D3953-17 GAS SPRING SPACER
D3953-19 GAS SPRING BRACKET
AN3-14A BOLT
NAS1149F0332P WASHER, 2X
MS21042L3 NUT
2 PL

D3953-3 GAS SPRING STUD, LID
D3953-7 GAS SPRING SPACER
D3953-9 GAS SPRING SPACER
NAS1149C0432R WASHER
AN310C4 NUT, CASTELLATED
MS24665-300 COTTER PIN

D3969-3 SPRING
REF

SECTION E-E B1-2

RELEASED
10.08.12

W1067884

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	4	HAWKESBURY, ONTARIO, CANADA	
CHECKED	4	DRAWING NO.	REV. C
MFG APPR.	JFS	D4030	SHEET 3 OF 3
APPROVED	4	TITLE	SCALE
DE APPR.	4	LONG BASKET-ASSY (350)	NTS
DATE	10.07.23	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

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